Dart Aerospace Ltd. Friday, 8/3/2007 6:28:16 AM Jean-Luc Menard User: **Process Sheet** : STEP SPACER **Drawing Name** : CU-DAR001 Dart Helicopters Services Customer Job Number : 33821 : 10375 **Estimate Number** : D30651 **Part Number** P.O. Number - D3065 REV. B : 8/3/2007 S.O. No. : **Drawing Number** This Issue : N/A Prsht Rev. : NC **Project Number** : SMALL /MED FAB : 11 **Drawing Revision** First Issue : 33510A Material **Previous Run** : 8/10/2007 **Due Date** Written By Checked & Approved By KJ/RF Incorporated D3066-1 IPP : Est:C 02.11.01 Comment 06.04.25 Water jet **EC** Est:D **Additional Product** Job Number: Description: **Machine Or Operation:** Seq. #: 2024-T3 .040 sheet 1.0 M2024T3S040 0.1300 sf(s)/Unit Total: 3.2498 sf(s) Comment: Qtv.: Material: 2024-T3 (QQ-A-250/4) 0.040" thick Batch: (M2024T3S.040) WATER JET 2.0 Comment: FLOW WATER JET 1-Cut as per Dwg D3065 Dwg Rev:_ Prog Rev:_ 2-Deburr as required INSPECT PARTS AS THEY COME OFF MACHINE 3.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 4.0 QC8 Comment: SECOND CHECK SMALL & MEDIUM FAB RESOURCE 1 5.0 SMALL FAB 1

Deburr if necessary.

Comment: SMALL & MEDIUM FAB RESOURCE 1

S'AV) 07-09-24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE			Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
·											
							-				
							-				

Part No: <u>D3065-</u>	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
			QA: N/C C	losed:	Date:

NCR: 3	3821	W	ORK OR	DER NON-CONFORMANC	E (NCR)			
		Description of NC		Corrective Action Section B		Verification	A	Approval QC Inspector
DATE	STEP	Section A	Initial) Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	
07/08/08	2,0	One part scrap had to change jet offset	/0x0/2	Scrap and destroy, repla	5 AM 8768/62	Posses	psian	
			1000		. 9	10408-08		0708.8

⁻ NOTE: Date & initial all entries

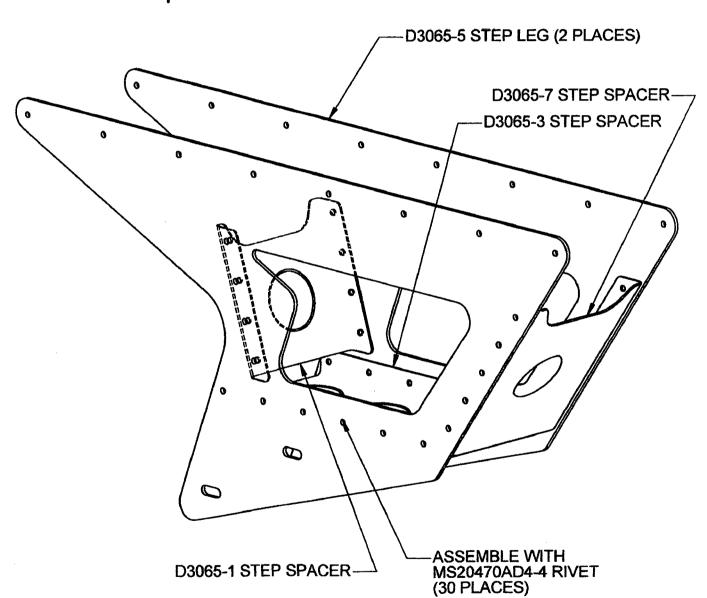
Date: User:	Friday, 8/3/2007 6 Jean-Luc Menard	3:28:16 AM	Process Sheet			
Custo	mer: CU-DAR001	Dart Helicopters Services	Drawing Name	: STEP SPACE	ER	
•		·	•			
	nber: 33821		Part Number	r: D30651	· · · · · · · · · · · · · · · · · · ·	
Job Number					,	
Seq. #:	Machine Or	Operation:	De	scription :		
6.0	BRAKE NC	#	NC BRAKE			
444 - 4						
Co	omment: NC BRAI	KE per Dwg D3065	Care.			100102 6
7.0	QC5	per Dwg D3003	INSPECT WORK TO CURREN	NT STEP	3/3 ()	103/21
						courts
		WORK TO CURRENT STEP	LIAND FINICHING RECOURCE	<u>)</u>	1000512	7(463)
8.0	HAND FINISH	HING1	HAND FINISHING RESOURC	·c #1		
Co	omment: HAND FI	NISHING RESOURCE #1			7 0 000	(28)
		Conversion Coat as per QSI 00		4-	7 08/03/	
9.0	dc3		INSPECT POWDER COAT/CH	HEMICAL CONV	ERSION	23.
		CHEMICAL CONVERSION CO	والمارات والمنافظ والمنافز والمنافر	<u> 1214</u>	68-03-	77
10.0	PACKAGING		PACKAGING RESOURCE #1	•		
Co		SING RESOURCE #1	111	<u></u>		
	Identify a Location:		- 43/28 P	58		
11.0	QC21		FINAL INSPECTIONW/O REL	EASE		.02
						08 OU 02
Co	omment: FINAL IN	SPECTION/W/O RELEASE				(8)
Job Completion			•	MF	08-03	- 28
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DESIGN	4	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CAI	
CHECK		APPROVED	DRAWING NO.	REV. B
	PH		D3065	SHEET 1 OF 5
DATE			TITLE	SCALE
	06.0	05.23	STEP LEG ASSEMBLY	1:2
Α	0	2.09.11	NEW ISSUE	
В	0	6.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS	TO D3065-5

RELEASED

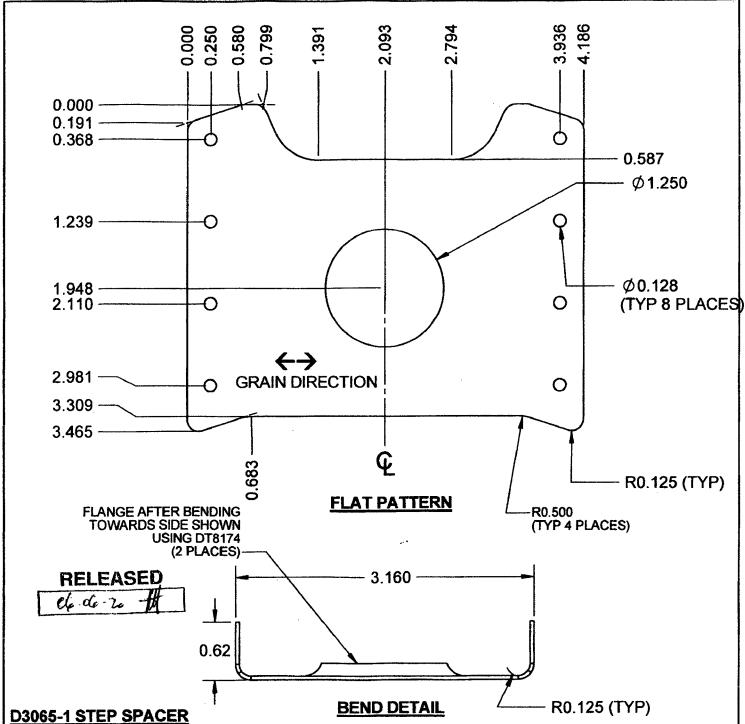
06 ck. 20 c



D3065-041 STEP LEG ASSEMBLY







1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040) 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1

3) BREAK ALL SHARP EDGES 0.005 TO 0.010

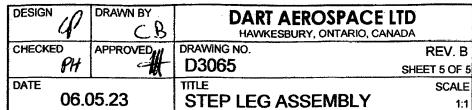
4) PART IS SYMMETRIC ABOUT CENTERLINE 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

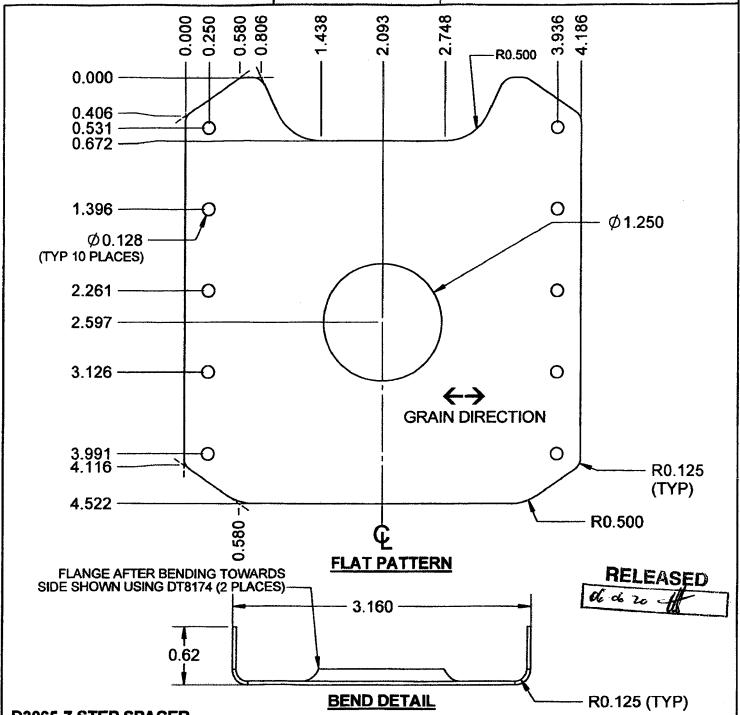
6) ALL DIMENSIONS ARE IN INCHES

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D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE LTD	Work Order:	3382
Description: Step Spacer	Part Number:	D3065-1
Inspection Dwg: D3065 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.250	+/-0.010	0.251	1		Vein	
2.093	+/-0.010	2.694			Vern	
3.936	+/-0.010	3.941	/		Vern	
4.186	+/-0.010	4.188			Vela	
0.587	+/-0.010	0.591			Se Height	all a
Ø0.128	+0.005/-0.001	Ø0.12,0	/		Vela	
R0.125	+/-0.010	80.115	/		R-6	
3.465	+/-0.010	3,462			Vern	
Ø1.250	+0.012/-0.001	01.250			Vern	
0.368	+/-0.010	0.362			Weight gas	
0.871 (Pitch)	+/-0.005	0.874	/		Vern	
0.040	+/-0.010	0.038			Vern	
-						
				1		

Measured by:	540	Audited by:		Prototype Approval:	
Date:	Olox108	Date:	07/08/09	Date:	IV(P

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D3065-041	KJ/RF	
В	06.06.23	Dwg Rev. changed	KJ/JLM	1
C		Dimension 0.040 added	KJ/JLM A	